	r ID 114469 06, 2014 9:24:30 AM	2	*112	1469*							Page 1	
Revision ID:	D3459-1 Float Step Mounting Plate	CC	Accept	*N900	040	100)* ፡	_	Start Stop		S1* S2*	
Start Date: 3 Required Date: 3 Reference:	Start Qty: 18.0 /12/2014 Req'd Qty: 18.0	117		Cust Item I Customer:	D:					14,		
	Process Plan:QC:	Date: <u> 4</u> 03 - 6 Date:	Tooling: SPC (Y/N):		nte:		R		Start Stop	*NI *NI	R1* R2*	
Sequence ID/ Work Center ID	Operation Description	THE COL	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		leject lumber	Insp. Stamp	_
Draw Nbr	Revision Nbr											-
D3459	Rev A						•					
¹⁰⁰ *1∩∩ *	FLOW WATER JET		0.00				20		B	14	-3-8	-
Waterjet FLOW CNC Waterjet	Dwg Rev Prog Rev	per Dwg D3459	0.00								<u> </u>	
110	QC2- Inspect parts of	f machine FAI/FAIB	0.00									
110 QC Quality Control	Memo		0.00				20	_&		<u>/y-3</u>	-8	
120	QC8- Inspect parts - s	second check	0.00		·		PTO				\Rightarrow	
1 20 ^{QC}	Memo		0.00									

Quality Control

DQA:		_ Date	:										TO AC
					WORK ORDER NON	I-CC	ONFO	RMANCE / U	PDATE				A E R O S P A C E
QA Closed:		Date	•							Wo	ork Order up	date only	
Work Ord	er:	1469			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
					Rework	7		Skid-tube	Crosstube			Water Jet 🔽	Engineering
Part I	vo. <u> </u>	459-	1		Scrap		Machining Small Fab				Pro	d. Eng. Coor.	Quality
	_	•			Use-as-is		Thermoforming Finishing				Rec/Stor	e/Packaging	Other
NCR No.					Suspected Unapproved		Large Fab Compos			2		Supplier	
Root				Desc	ription of work order update	1	nitial	Ac	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling	14/3/K	1 100	20	Pa	of serap halo			scrop o	Destra	by	E [14.3.2]	DAS 38	DAS 9
Handling/Pre	H		1		a decendo o	1)	. 21	9-89	9-89
Material				00	side of	1	>				14.3.01		1110650
Operator	7					0	1.9/2h					14-9-26	142650
Offset/Setup						"							
Process	X			[K_C	the programy	14	1,9/26						
Supplier													
Training				lobry	the same								
Transport													
Unapproved	L. I	_}		<u>L</u>		<u> </u>						·	
						FAL	JLT CA	TEGORY					
Landi	ng Gear				General	DE X	.	_			l	_	٦
	Bending	_		-	Bend	7	1	Program		-	Outside Dim	—	Pressure/Forced
	\vdash	Not Conce	intric		BOM/Route		Grain			-//-	Over/Under	-	Set-up
	Cracks	dialidataal	- //4/		Broken/Damage/Defect	\vdash	Hardwa		1.6.	_	Part Incorred	-	Temperature/Cure
	—	(ink/Ripple	e/wave	-	Burrs	-	,	ion Incomplete/U	•	_	Part Lost/Mi	· -	Weld
	Cuffs	_		-	Contamination	-		tions Incomplete/	Unclear	_	Part Moved	<u>-</u>	Wrong Stock Pulled
	Crushin			-	Countersink	-	`	gned/off center		\vdash	Positioned V		Jan
	Heat Treat Cut Too Short Inspection Strip in Tube Drawing			-	-	Mislabe			L	Power Loss/	Surge []	Other	
	Marks/		rube	-	Drawing Drill Holes		Misread						
	⊢ .	Sequence	,		Finish	\vdash	Off-set						
		wist in Tu		-	Fit/Function	-		Calibration Sequence					
	i lasarc/i	4412 C 111 1 M		1	priyrancaon		JULIU 3	JEQUEITE					

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Work Order ID 114469 *114469* Page 2 Thursday, March 06, 2014 9:24:31 AM Item ID: D3459-1 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Float Step Mounting Plate **Start Date: Start Qty: 18.00** *18* 3/6/2014 **Cust Item ID: Required Date:** 3/12/2014 Req'd Qty: 18.00 *18* **Customer:** Reference: Run Start **Approvals:** Process Plan: _____ Date:_____ **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Insp. Accept Reject **Work Center ID Description Run Hours** Code Qty Qty Number Stamp 130 Identify as per dwg & Stock Location: 0.00 *120* Packaging 0.00 Memo Packaging *** STOCK IN STEP CELL***

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

OC

140

Quality Control

m5 1400 29 mf g-26

DQA:		Date										
					WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE			A E R O S P A C E
QA Closed:		Date	•						V	ork Order up	date only	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
					Rework	Rework		Skid-tube Crosstube			Water Jet	Engineering
Part N	lo				Scrap		Machining Small Fab		Prod. Eng. Coor.		Quality	
					Use-as-is		Therr	moforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	NCR No.			_	Suspected Unapproved			Large Fab	Composite		Supplier	
Root	oot De		Desci	ription of work order update		nitial	Acti	ion	Sign &	******		
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design												
Doc/Data					·							
Equip/Tooling	_						,					
Handling/Pre		;										
Material												
Operator	_		l									
Offset/Setup	_		1									
Process												
Supplier												
Training -					,							
Transport	_											
Unapproved			<u> </u>	l			UT CA	TECODY				<u> </u>
Landir	ng Gear					FAI	JLI CA	TEGORY				
Lanuii	Bendi	na			General Bend		ralia/r	Program	Г	Outside Dim		Pressure/Forced
}	—	ਾਫ e Not Conce	ntric		BOM/Route	⊢	Grain	riograffi	-	Over/Under	·	Set-up
ŀ	Crack		intric		Broken/Damage/Defect		Hardwa	are.		Part Incorred		Temperature/Cure
ŀ		/Kink/Rippl	e/Wave		Burrs	\vdash	ı	ion Incomplete/Un	gualified	Part Lost/Mi		Weld
	Cuffs	,,pp	c, wave	-	Contamination		! ·	tions Incomplete/U	· —	Part Moved		Wrong Stock Pulled
Ì	Crush	ing			Countersink		1	gned/off center	-	Positioned V		Toug Stock i diled
<u> </u>	Heat	_			Cut Too Short		Mislab	-	-	Power Loss/		Other
		ction Strip ir	n Tube		Drawing	П	Misrea		L			1
Ī		/Chatter			Drill Holes	Г	Off-set					
				Finish		ļ	Calibration					
	Wave	/Twist in Tu	be		Fit/Function		Out of	Sequence				

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: Picklist Print

Thursday, March 06, 2014 9:25:03 AM

Work Order ID: 114469

114469

Parent Item:

D3459-1

D3459-1

Parent Item Name: Float Step Mounting Plate

Start Date: 3/6/2014

Required Date: 3/12/2014

Start Qty: 18.00

Required Qty: 18.00

Comments:

IPP Rev: A

New Issue 06-01-06 JLM

IPP Rev: B

Waterjet 06-05-23

Component Item ID/ Item Name

Replacement Mfg/ Item ID Purch

Bin **Primary** Item Location

Last Location

Route Seq ID Unit of Measure

Qty on Qty per Kit Total Hand Qty

**

Qty **Issued**

Date Status Issued

Page 1

M6061T6B0.187X04.00

Purchased -

No

100

f

27.5000

0.347 7

14.3.8

M6061T6B0 187X04 000

6061-T6 Bar .187 x 4.00

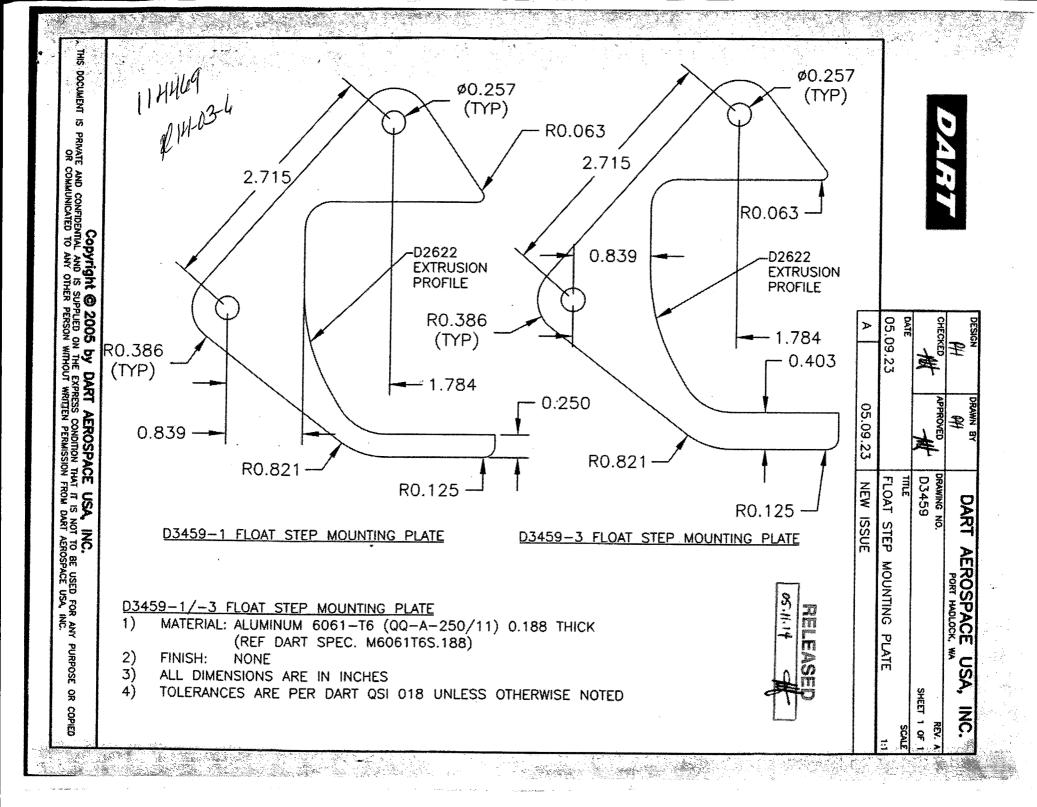
Location

MAT051 m128265 Loc Oty

27.5 27.5 Loc Code

DQA:		Date:	:		- WORK ORDER NON-CONFORMANCE / UPDATE						DART	
QA Closed:		Date	:		WORK ORDER NON-	-((JINFOI	RIVIAINCE / U		/ork Order up	odate only	AEROSPACE
Work Orde	er:				DISPOSITION							
Part N	Part No. NCR No.			Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fa Thermoforming Finishin		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root				Descr	ription of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
						FAL	ULT CAT	regory				
Landir	Centre Not Concentric BO Cracks Bro Crimp/Kink/Ripple/Wave Bur Cuffs Con Crushing Con Heat Treat Cut Inspection Strip in Tube Dra Marks/Chatter Dri		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration			Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
		Twist in Tu			Fit/Function		1	Sequence				

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DQA:		Date:	·		WORK ORDER NON-	-CC	ONFOR	RMANCF / L	JPDATE:			DART
QA Closed:		Date:			TOTAL ORDER HOR		3111 01			ork Order up	odate only	AEROSPACE
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part No. NCR No.			Rework Scrap Use-as-is Suspected Unapproved	Scrap Use-as-is The		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Water Je Prod. Eng. Coor Rec/Store/Packaging Supplie		Engineering Quality Other		
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance	1	nitial ief Eng		ction cription	Sign & Date	Verification	n QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
						FA	ULT CAT	EGORY				
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1	Marks/Chatter				Drill Holes	1	Off-set					

Out of Calibration

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Finish

Fit/Function

DART AEROSPACE LTD	Work Order:	
Description: Float Step Mounting Plate	Part Number:	D3459-1
Inspection Dwg: D3459 Rev: A		Page 1 of 1

	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	X	First Artic	le	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
Ø0.257	+0.006/-0.001	0.262	1		5/m05		- 444
2.715	+/-0.010	2.712	8				
0.250	+/-0.010	0.25	/				
R0.125	+/-0.010	R. 125					
R0.063	+/-0.010	R.063		-		-	
0.839	+/-0.010	0.839	/				
0.188	+/-0.010	0.187					
loogured by:	a	Audited bu					
leasured by:		Audited by:			Prototype Appr		N/A
Date	1.1 2/1	Date:		1 1		Data	NI/A

Measured by:	EL	Audited by:	Prototype Appro	val: N/A
Date:	14-3-8	Date:		ate: N/A

Rev	Date	Change	Revised by	Approved
Α	07.09.26	New Issue	KJ/EC/DD	- 62
			·	<u></u>